

Work Order ID 81771

81771

Page 1

March-19-12 10:18:18 AM

Item ID: D350-604-041

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Rear Locker Extender

Start Date: 3/19/12 Start Qty: 1.00

1

Cust Item ID:

Required Date: 3/19/12 Req'd Qty: 1.00

1

Customer:

Reference: rework - ECN09-626

Approvals: Process Plan: *[Signature]*

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
----------	--------------

D2273	E
-------	---

D350-604-041	C
--------------	---

100

0.00

100

DOCUMENT CONTROL

DC

Memo

0.00

Document Control

Photocopy bluefile and create labels per PPP D350-604-041 CHG002

Handwritten: 52 12/3/20 *Signature* MLJ 12-3-19 (1)

125

0.00

125

Small Fab

Memo

0.00

Small Fab

PULL FROM STOCK:

1 X D350-604-041 B39324 CHG001

REMOVE STUDS 2600-4 AND RETAINING RING - DISCARD

REPLACE WITH 2600-6 B *120677* RETAINING RING 2600-LW B *120648*

PER ECN 09-626, DSI 9470

Handwritten: 12-03-19

DART Dart Aerospace Ltd. 1270 ABERDEEN ST. HAWKESBURY, ONT CANADA K6A 1K7				TC APPROVAL # 09-89 TEL: 1-613-632-5200	
P/N	D350-604-041	CHG	CHG001		
DESC	Rear Locker Extender	SIC	SH90-4		
LOT	B39324	SIC	SR00463NY		
MODEL	AS350/355	SIC			
MADE IN CANADA					

Work Order ID 81771

March-19-12 10:18:18 AM

81771

Page 2

Item ID: D350-604-041

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Rear Locker Extender

Start Date: 3/19/12 Start Qty: 1.00

1

Cust Item ID:

Required Date: 3/19/12 Req'd Qty: 1.00

1

Customer:

Reference: rework - ECN09-626

Approvals: Process Plan: _____ Date: _____

Tooling: _____ Date: _____

Run Start

NR1

QC: _____ Date: _____

SPC (Y/N): _____ Date: _____

Stop

NR2Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130

QC5- Inspect part completeness to step on W/O

0.00

130

QC

Memo

0.00

Quality Control

12/3/20

1

140

Pick Kit

0.00

140

Packaging

Memo

0.00

Packaging

12/3/19



150

QC4- 100% Inspect kits for completeness

0.00

150

QC

Memo

0.00

Quality Control

12/3/20

1

Picklist Print

March-19-12 10:18:18 AM

Page 1

Work Order ID: 81771

Parent Item: D350-604-041

Parent Item Name: Rear Locker Extender

Start Date: 3/19/12

Required Date: 3/19/12

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:Q03.12.01ReformatKJ/RF
521 DD verf:JLM

IPP REV:R 12.02.07 AS PER ECN12-

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
2600-6 Camlock Stud		Purchased	No				Each	130.0000					
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST380		130							
				120077		130							
2600-LW Camloc Retaining Washer		Purchased	No				Each	93.0000					
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST398		93							
				120648		93							
D350-604-041 Rear Locker Extender		Manufactured	No				Each	1.0000					
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				FG052		1							

DART SERVICE INSTRUCTION

TO AMEND INSTALLATION INSTRUCTIONS D350-604 REV. B

REF TCCA STC: SH90-4

REF FAA STC: SR00463NY

8771

PURPOSE:

The 2600-4 Camloc Studs may be too short for some installations.

CHANGE:

The qty (4) 2600-4 Camloc Studs are replaced with longer 2600-6 Camloc Studs. It is acceptable to install either 2600-4 or 2600-6 Camloc Studs. The parts list of D350-604 Rev. B is amended as follows:

QTY	PART NUMBER	DESCRIPTION
-041		
X	D350-604-041	REAR CARGO COMPARTMENT EXTENDER ASS'Y

IS:

4	2600-6	CAMLOC STUD
---	--------	-------------

WAS:






4	2600-4	CAMLOC STUD
---	--------	-------------

CANADA
DEPARTMENT OF TRANSPORT
AIRCRAFT CERTIFICATION
BRANCH
DAO # 01-O-01

APPROVED

BY: 
D. SHEPHERD (DE # 02)

DATE: 09.07.01
CERT. NO.: SH90-4
ISSUE NO.: 3

A	NEW ISSUE, NCR 09-046	CP	09.07.01
REV.	DESCRIPTION	BY	DATE
DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.	N/A	DSI 9470	SHEET 1 OF 1
APPROVED		TITLE	SCALE
DE APPR.		CAMLOC CHANGE	NTS
DATE	09.07.01	COPYRIGHT © 2009 BY DART AEROSPACE LTD	
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Change Record

Part Number D350-604-04
Description Rear Locker Extender

Page 1 of 1

Chg.	Date	By	Relevant Documents
001	99.08.12	CS / RE	D2273 Rev. B D2268 Rev. B D2269 Rev. B D350-604 Rev. B
002	09.07.15	RE	DS19470 Rev. A (ECN 09-626)
003	12.02.06	RE	D2273 Rev. E (ECN 12-521)
	12.02.22	RE	D350-604 Rev. C, ICA-D350-604 Rev. D SH90-4 Issue 4 (ECN 12-531)

Date: Friday, 16/05/2008 8:46:05 AM
User: Julie Lecocq

Process Sheet

Customer :	CU-DAR001 Dart Helicopters Services	Drawing Name :	REAR LOCKER EXTENDER
Job Number :	39324		
Estimate Number :	10719		
P.O. Number :		Part Number :	D350604041
This Issue :	16/05/2008- S.O. No. :	Drawing Number :	D2273/D350-604-041
Prsht Rev. :	NC	Project Number :	N/A
First Issue :	// Type : PURCHASED PARTS	Drawing Revision :	D/A1
Previous Run :	39323	Material :	
Written By :		Due Date :	15/06/2008 Qty: 1 Um: Each
Checked & Approved By :	JUP 08.5.16		
Comment :	Est Rev:Q 03.12.01 Reformat KJ/RF		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

1.0	DC	DOCUMENT CONTROL
-----	----	------------------



Comment: DOCUMENT CONTROL
Photocopy bluefile and create labels per PPP D350-604-041CHG001

JLD
08.5.21

2.0	PG	PURCHASING
-----	----	------------



Comment: PURCHASING
Issue P/O: 6388 C208/05/20 ①
Description: D350-604-041 Rear locker extender.
Supplier: Delastek.
Certification of Conformity and process sheet from Delastek is required. 4 x 2600-4
Camlock stud
ship to Delastek B m106864

3.0	26004	Camlock stud
-----	-------	--------------



Comment: Qty.: 4.0000 Each(s)/Unit Total: 4.0000 Each(s)

4.0	D350604041P	rear locker extender
-----	-------------	----------------------



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)
Rear Locker Extender

5.0	PACKAGING 1	PACKAGING RESOURCE #1
-----	-------------	-----------------------



Comment: PACKAGING RESOURCE #1
Receive and inspect for transit damage. Ensure a copy of Certification of Conformity and process sheet from Delastek is attached.

08/5/12 ①

Date: Friday, 16/05/2008 8:46:05 AM
User: Julie Lecocq

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: REAR LOCKER EXTENDER

Job Number: 39324

Part Number: D350604041

Job Number:



Seq. #:

Machine Or Operation:

Description:

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: Check hole locations to template. DT 8824 Check process sheet and audit.

508/06/13 @

7.0

D2268

Decal



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Pick:

Qty Part# Description
1 D2268 Placard

Batch

B38354

sc

8.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Pick Packing Kit

Place D2268 decal as per Dwg D350-604-041.

sc

9.0

D2269

Decal



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Pick: for shipment with part

Qty Part Number Description
1 D2269 Placard

Batch

99010

8/6/13

sc

10.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

508/06/13 @

11.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D350-604-041

Location:

PPP Rev:

50E

8/6/13

sc

12.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/06/16

Job Completion



h 08-06-16



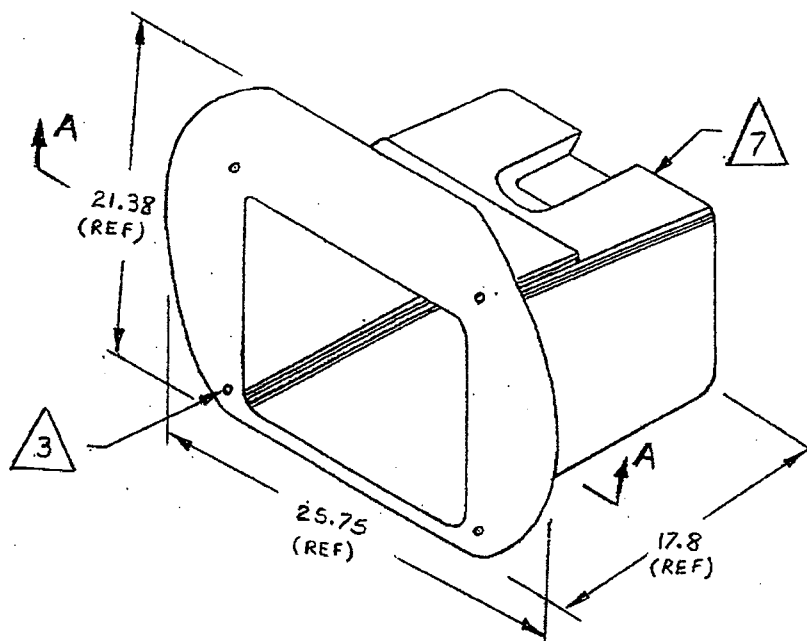
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DART



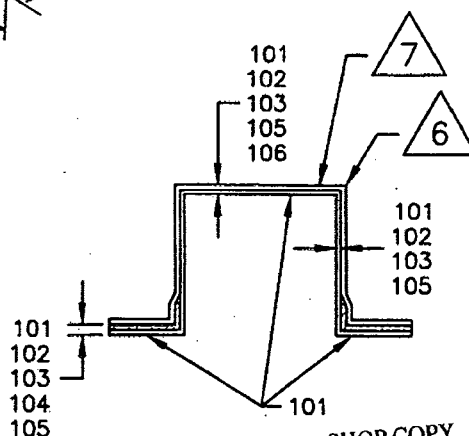
DESIGN JB	DRAWN BY <i>JP</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>JP</i>	APPROVED <i>JP</i>	DRAWING NO. D2273	REV. D SHEET 1 OF 1
DATE 02.04.01	TITLE 350 REAR LOCKER EXTENDER		SCALE NTS
B	96.05.27	RE-DRAWN	
C	02.01.30	CLARIFY MATERIAL, LAYUP, AND TOOLING	
D	02.04.01	REMOVE EPOCAST, ADD SURFACE FINISH	

RELEASED
02.04.03



NOTES:

- 1) LAMINATE PER DART QSI 006. LAMINATION SCHEDULE PER THIS DRAWING.
- 2) LAYUP USING DT8010 MOLD. WET LAYUP NO BAG/VACUUM.
- 3) TRIM & DRILL PER DT8020. OPEN HOLES TO $\phi 0.257$ (4 PLACES).
- 4) MATERIALS:
RESIN: DERAKANE 470-36/411/510A40
FIBRE: 9oz = 9.7 oz 7781 WEAVE "S" GLASS
18oz = 18.0 oz ROVING "E" GLASS.
- 5) CONSTRUCTION:
101-WHITE GLOSS GELCOAT # GEL 944W005.
102-9oz ALL OVER.
103-18oz ALL OVER.
104-18oz RE-INFORCE FRONT FLANGE EXTENDING 2" ON SIDES.
105-9oz ALL OVER.
106-PEEL PLY.
- 6) MATTE TO HOLD DOWN CORNERS AS REQUIRED.
- 7) FINISH THIS SURFACE WITH DUPONT HIGHBUILD GREY PRIMER 1144-S.
- 8) ALL DIMENSIONS ARE IN INCHES.



SHOP COPY
SECTION A-A RETURN TO
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WORK ORDER
NO. 31324

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DELASTEK COMPOSITES INC.
2699, 5^{ème} Avenue
Local 14, PORTE -A-
Grand-Mère, Québec G9T 5K7
Can. **Fax (819) 533-3494 **

PACKING SLIP CERTIFICATE OF COMPLIANCE

Invoice #	12757
Customer #	DART

Telephone: (819) 533-5788

Warehouse: MAIN

Bill to:

Dart Aerospace Ltd.
1270, Aberdeen Street
Hawkesbury, Ontario K6A 1K7
Canada

Ship to:

Dart Aerospace Ltd.
1270, Aberdeen Street
Hawkesbury, Ontario K6A 1K7
Canada

Telephone: 613-632-5200

Contact: Linda Lacelle

Ship via		F.O.B.		Terms		Salesperson	
PURO COLLECT		Origin		Net30 days		Claude Lessard, ext. 233	
Ship date	Order Date	Our PO #	Order by		Your PO #	GST/PST #	
11/06/2008	20/05/2008	5806	C. Lavoie		PO00006388		
Order Qty	B.O. Qty	Current Ship.	Item #	Item Description			
1	0	1	DKC134-0003	Rear Locker Extender D350-604-041P B39323 Référence DKA362-0004 DWG: D350-604-041 REV. A1 D2273 REV. D Job: 43005 U de M : Each			
1	0	1	DKC134-0003	Rear Locker Extender D350-604-041P B39324 Référence DKA362-0004 DWG: D350-604-041 REV. A1 D2273 REV. D Job: 43074 U de M : Each			

It is hereby certified that all materials, process and finished items were controlled and tested in accordance with the requirements of the purchase order and applicable specifications. All such records are on file at our plant and available for review upon request.

☒ Cust. ☐ Adm. ☐ Quality ☐ Ship.

Accepted by:

Quality department


AQ-357



Date: Vendredi, 2008-05-23 11:47:01
Utilisateur: Marc Dubé

Feuille de Procédé

Client :	DART	Dart Aerospace Ltd.	Nom Dessin :	REAR LOCKER EXTENDER
Numéro Job :	43074		Numéro Article :	DKC134-0003
Numéro Soumission :	1708		Numéro Dessin :	D350-604-041 & D2273
Numéro B.A. :			Projet Numéro :	DKC134
Cette fois :	2008-05-23	No. B.V. :	Révision dessin :	A & D
Prsht Rev. :	NC		Matériel :	Résine Derakane 470-36/411/510
Prem. fois :	- -	Type :	Date Due :	2008-05-30
Job précédente :	43073		Qté:	1 Udm: UNITE

Écrit par : 
Vérifié & Approuvé par :
Commentaires : N° de pièce Laminée Dart Aerospace: D2273
N° de pièce Assemblée Dart Aerospace: D350-604-041
N° de pièce Delastek Aeronautique: DKA362-0004
N° de pièce Delastek Composites: DKC134-0003

Process Sheet Rév.: 12 Modification des séquence pour y inclure les N° d'instruction de fabrication.

Produit additionnel

Numéro Job:



# Séq.:	Machine ou Opération:	Description :
1.0	AC0303	Frekote 44NC

Commentair Qty.: 0.017 UNITE(s)/Unit Total: 0.017 UNITE(s)
Frekote 44NC

2.0	PRÉPARATION 3	PRÉPARATION DU MATÉRIEL DART
-----	---------------	------------------------------




Commentair Setup: 0.00Hrs/ Run: 15.0000Min Total Run: 0.2500Hrs
PRÉPARATION DU MOULE

Nettoyer le moule à l'aide d'un chiffon humide et sécher à l'air. Selon I.F. # DKC134-0003-5.

Note: Afin que le frekote agisse pleinement, le moule doit être libre de toute contamination, enlever tout contaminants à l'aide de Frekote PMC, PMC Plus ou tout autre solvant afficace. Il est permit d'utiliser un abrasif (Doux) afin d'enlever tout accumulation de résine sur le moule.

Appliquer 2 couches de Frekote 44-NC à l'aide du chiffon propre en laissant sécher pendant 15 minutes entre les couches. Le séchage de la dernière couche doit être de 3 heures à température de la pièce avant d'appliquer le Gel Coat.

Quantité: 1 Date: 5 Juin 08 Sceau: 

Quantité: _____ Date: _____ Sceau: _____

Quantité: _____ Date: _____ Sceau: _____

Quantité: _____ Date: _____ Sceau: _____

Date: Vendredi, 2008-05-23 11:47:02

Utilisateur: Marc Dubé

Feuille de Procédé

Client: DART Dart Aerospace Ltd.

Nom Dessin: REAR LOCKER EXTENDER

Numéro Job: 43074

Numéro Article: DKC134-0003

Numéro Job:



# Séq.:	Machine ou Opération:	Description :
---------	-----------------------	---------------

3.0	AAC0273	Gel Coat Blanc N° Gel 944W005
-----	---------	-------------------------------

Commentair Qty.: 1.575 KILOGRAMME(s)/Unit Total : 1.575 KILOGRAMME(s)
Gel Coat Blanc N° Gel 944W005 N° de Lot: 1-6655-2

4.0	AAC0275	Catalyst N° DDM-9
-----	---------	-------------------

Commentair Qty.: 0.0066 PINTE(s)/Unit Total : 0.0066 PINTE(s)
Catalyst N° DDM-9 N° de Lot: 1-6270-1

5.0	AC0260	Acetone
-----	--------	---------

Commentair Qty.: 0.200 UNITE(s)/Unit Total : 0.200 UNITE(s)
Acetone

6.0	PRÉPARATION 3	PRÉPARATION DU MATÉRIEL DART
-----	---------------	------------------------------



Commentair Setup: 0.00Hrs/ Run: 30.0000Min Total Run : 0.5000Hrs
PRÉPARATION DU MATÉRIEL

Faire la préparation du matériel selon I.F. # DKC134-0003-5 :

Dans une quantité de Gel Coat N° 944W005 ajouter 2% de Catalyst N° DDM-9 et diluer à l'aide de 10% D'acétone.

Quantité: 1 Date: 9 Juin 08 Sceau: 

Quantité: _____ Date: _____ Sceau: _____

Quantité: _____ Date: _____ Sceau: _____

Quantité: _____ Date: _____ Sceau: _____

7.0	GEL COAT	APPLICATION DE GEL COAT
-----	----------	-------------------------



Commentair Setup: 0.00Hrs/ Run: 20.0000Min Total Run : 0.3333Hrs
APPLICATION DE GEL COAT

Selon I.F. 134-0003

À l'aide d'un fusil à gel coat appliquer une couche entre 15 et 20 millièmes de Gel Coat sur le moule N° DKG 362-010 et laisser sécher pendant un minimum de 2 heures avant de faire le lay-up, mais ne pas dépasser 24 heures de séchage selon l'instruction de travail N° Tec-70.

Note: Le gel coat ne doit contenir aucun "airdry" ni aucune cire. Et le temp de séchage est important afin d'éviter d'avoir des défauts de surface, et afin d'éviter que le tissu ne vienne marquer au travers du Gel Coat ainsi que d'éviter d'avoir un rétrécissement.

Autocontrôle de fabrication. (Visuel du Gel Coat)

Quantité: 1 Date: 9 Juin 08 Sceau: 

Date: Vendredi, 2008-05-23 11:47:02
Utilisateur: Marc Dubé

Feuille de Procédé

Client: DART Dart Aerospace Ltd.
Numéro Job: 43074

Nom Dessin: REAR LOCKER EXTENDER
Numéro Article: DKC134-0003

Numéro Job:



Séq.: Machine ou Opération: Description :

Quantité: _____ Date: _____ Sceau: _____

Quantité: _____ Date: _____ Sceau: _____

Quantité: _____ Date: _____ Sceau: _____

8.0 AAC0324 Résine (411B7530) 411-350 promo. 75min.

Commentair Qty.: 1.680 KILOGRAMME(s)/Unit Total: 1.680 KILOGRAMME(s)
Résine (411B7530) 411-350 promo. 75min. N° de Lot: 1-20945-1

9.0 AAC0275 Catalyst N° DDM-9

Commentair Qty.: 0.0063 PINTE(s)/Unit Total: 0.0063 PINTE(s)
Catalyst N° DDM-9

N° de Lot: 1-6270-1

10.0 AAC0326 9.7 oz Weave "S" glass #FG-778150-125Y Volan Finish

Commentair Qty.: 4.6 VERGE(s)/Unit Total: 4.6 VERGE(s)
9.7 oz 7781 Weave "S" glass #FG-778150-125Y N° de Lot: 2-6476-1

11.0 AAC0277 Fiberglass 18oz Type "E" N° WR1850

Commentair Qty.: 1.14 UNITE(s)/Unit Total: 1.14 UNITE(s)
Fiberglass 18oz Type "E" N° WR1850 N° de Lot: 1-6476-3

12.0 PRÉPARATION 3 PRÉPARATION DU MATÉRIEL DART



Commentair Setup: 0.00Hrs/ Run: 45.0000Min Total Run: 0.7500Hrs
PRÉPARATION DU MATÉRIEL

Tailler le matériel selon les dimensions requises à l'aide de gabarit de trimage prévus à cet effet.

Autocontrôle de fabrication. (Selon gabarits)

Quantité: 1 Date: 8 mai 08 Sceau:

Quantité: _____ Date: _____ Sceau: _____

Quantité: _____ Date: _____ Sceau: _____

Quantité: _____ Date: _____ Sceau: _____

13.0 LAMINAGE. - LAMINAGE-PIÈCE DART -



Commentair Setup: 0.00Hrs/ Run: 3.5000Hrs Total Run: 3.5000Hrs
FAIRE LE LAMINAGE DES TISSUS

Selon I.F. 134-0003

Date: Vendredi, 2008-05-23 11:47:02

Utilisateur: Marc Dubé

Feuille de Procédé

Client: DART Dart Aerospace Ltd.

Nom Dessin: REAR LOCKER EXTENDER

Numéro Job: 43074

Numéro Article: DKC134-0003

Numéro Job:



Séq.:

Machine ou Opération:

Description :

S'assurer de ne pas trapper d'air entre les rangs

Inscrire les informations suivantes:

Humidité: 44% ; _____ ; _____ ; _____

Température: 78.8°F ; _____ ; _____ ; _____

Heure: 3:15 ; 4:20 ; _____ ; _____

Date: 9/06/08 ; _____ ; _____ ; _____

Quantité: 1 Date: 9/06/08 Sceau:  

Quantité: _____ Date: _____ Sceau: _____

Quantité: _____ Date: _____ Sceau: _____

Quantité: _____ Date: _____ Sceau: _____

14.0

AAC0324

Résine (411B7530) 411-350 promo. 75min.

Commentair Qty.: 0.150 KILOGRAMME(s)/Unit Total: 0.150 KILOGRAMME(s)

Résine (411B7530) 411-350 promo. 75min.

N° de Lot: 1-20945-1

15.0

AAC0275

Catalyst N° DDM-9

Commentair Qty.: 0.0063 PINTE(s)/Unit Total: 0.0063 PINTE(s)

Catalyst N° DDM-9

N° de Lot: 1-6270-1

16.0

FINITION 3

FINITION PIÈCE DART



Commentair Setup: 0.00Hrs/ Run: 0.0000Min Total Run: 0.0000Hrs

FINITION PIÈCE DART

Injecter les bulles d'air selon I.F. # DKC134-0003-5.

Quantité: 1 Date: 9 Juin 08 Sceau: 

Quantité: _____ Date: _____ Sceau: _____

Quantité: _____ Date: _____ Sceau: _____

Quantité: _____ Date: _____ Sceau: _____

Date: Vendredi, 2008-05-23 11:47:02
Utilisateur: Marc Dubé

Feuille de Procédé

Client: DART Dart Aerospace Ltd. Nom Dessin: REAR LOCKER EXTENDER
Numéro Job: 43074 Numéro Article: DKC134-0003

Numéro Job:



Séq.: Machine ou Opération: Description :

17.0

DÉMOULAGE 1

DÉMOULAGE PIÈCE DART



Commentaire Setup: 0.00Hrs/ Run: 10.0000Min Total Run : 0.1667Hrs
DÉMOULAGE DES PIÈCES.

Selon I.F.# DKC134-0003-5.

Faire le démoulage de la pièce en poussant de l'air à l'intérieur tout en faisant bien attention de ne pas l'endommager.

Autocontrôle de fabrication.(Visuel)

Quantité: 1 Date: 10 Juin 08 Sceau:

Quantité: _____ Date: _____ Sceau: _____

Quantité: _____ Date: _____ Sceau: _____

Quantité: _____ Date: _____ Sceau: _____

18.0

TRIMAGE 3

TRIMAGE COMPOSITES DART



Commentaire Setup: 0.00Hrs/ Run: 40.0000Min Total Run : 0.6667Hrs
TRIMAGE DE FINITION

Selon I.F.134-0002

Autocontrôle de fabrication.(Visuel et dimensionnel selon le dessin)

Quantité: 1 Date: 10 Juin 08 Sceau:

Quantité: _____ Date: _____ Sceau: _____

Quantité: _____ Date: _____ Sceau: _____

Quantité: _____ Date: _____ Sceau: _____

19.0

AAC0683

Dupont Primer N° 7704S

Commentaire Qty.: 0.3330 UNITE(s)/Unit Total: 0.3330.UNITE(s)
Dupont Primer N° 7704S N° de Lot: 1-6565-1

Date: Vendredi, 2008-05-23 11:47:02

Utilisateur: Marc Dubé

Feuille de Procédé

Client: DART Dart Aerospace Ltd.

Nom Dessin: REAR LOCKER EXTENDER

Numéro Job: 43074

Numéro Article: DKC134-0003

Numéro Job:



Séq.:

Machine ou Opération:

Description :

20.0

AAC0685

Dupont Activator - Reducer Chromabase N° 7775S

Commentair Qty.: 0.0667 UNITE(s)/Unit Total : 0.0667 UNITE(s)

Dupont Activator - Reducer Chromabase N° 7775S

21.0

PRIMER

APPLICATION DE PRIMER



Commentair Setup: 0.00Hrs/ Run: 0.0000Hrs Total Run : 0.0000Hrs

APPLICATION DE PRIMER

Appliquer le primer selon I.G. 0008

Quantité: 1 Date: 10/06/08 Sceau:

Quantité: _____ Date: _____ Sceau: _____

Quantité: _____ Date: _____ Sceau: _____

Quantité: _____ Date: _____ Sceau: _____

22.0

AAC0280

Camlock Stud 2600-4 (or Monadnock 1126000-4)

Commentair Qty.: 4 UNITE(s)/Unit Total : 4 UNITE(s)

Camlock Stud 2600-4 (or Monadnock 1126000-4)

N° de Lot: 1-6612-1

23.0

AAC0103

Washer 2600-LW (1127700)

Commentair Qty.: 4.0 UNITE(s)/Unit Total : 4.0 UNITE(s)

Washer 2600-LW (1127700)

N° de Lot: 2-5845-5

24.0

ASSEMBLAGE 3

ASSEMBLAGE GÉNÉRALE DART



Commentair Setup: 0.00Hrs/ Run: 15.0000Min Total Run : 0.2500Hrs

ASSEMBLAGE GÉNÉRALE DES PIÉCES

Selon I.F. 134-0004

Démasquer la pièce.

Assembler les quatre (4) Camlock Stud N° 2600-4 à l'aide des Lock Washer N° 2600-LW. Selon l'instruction de travail N° I.G.#Pose de stud.

Autocontrôle de l'assemblage (Visuel)

Quantité: 1 Date: 11/06/08 Sceau:

Quantité: _____ Date: _____ Sceau: _____

Quantité: _____ Date: _____ Sceau: _____

Quantité: _____ Date: _____ Sceau: _____

Date: Vendredi, 2008-05-23 11:47:02

Utilisateur: Marc Dubé

Feuille de Procédé

Client: DART Dart Aerospace Ltd.

Nom Dessin: REAR LOCKER EXTENDER

Numéro Job: 43074

Numéro Article: DKC134-0003

Numéro Job:



Séq.:

Machine ou Opération:

Description:

25.0

IDENTIFICATION4

IDENTIFICATION PIÈCES DART



Commentaire Setup: 0.00Hrs/ Run: 10.0000Min Total Run : 0.1667Hrs
IDENTIFICATION DES PIECES

Selon I.F. 134-0005

Faire l'identification de la pièce: N° de pièce D350-604-041

N° de Work Order: _____

L'identification doit être vers l'extérieur.

Quantité: 1 Date: 11 Jun 08 Sceau:

Quantité: _____ Date: _____ Sceau: _____

Quantité: _____ Date: _____ Sceau: _____

Quantité: _____ Date: _____ Sceau: _____

26.0

INSPECTION 3

INSPECTION PIÈCE DART



Commentaire Setup: 0.00Hrs/ Run: 10.0000Min Total Run : 0.1667Hrs
INSPECTION GÉNÉRALE

Faire l'inspection dimensionnelle et visuelle de la pièce selon le dessin.

Quantité: 1 Date: 11-6-08 Sceau: Initiales: MS

27.0

EMBALLAGE

EMBALLAGE ET ENTREPOSAGE



Commentaire Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs
EMBALLAGE ET ENTREPOSAGE

Faire l'emballage de la pièce dans le contenant approprié.

Quantité: 1 Date: 11 Jun 08 Sceau:

Quantité: _____ Date: _____ Sceau: _____

Quantité: _____ Date: _____ Sceau: _____

Quantité: _____ Date: _____ Sceau: _____

L Lacelle

From: Jason Murdoch [jmurdoch@dartaero.com]
Sent: August 7, 2009 9:01 AM
To: 'Chris Provencal'; 'Dan Stow'; 'L Lacelle'; 'Mike Petsche'
Subject: RE: ECN09-626

Git'er Done

Jason Murdoch
Quality Coordinator
jmurdoch@dartaero.com

From: Chris Provencal [mailto:cprovencal@dartaero.com]
Sent: August 7, 2009 8:57 AM
To: 'Jason Murdoch'; 'Dan Stow'; 'L Lacelle'; 'Mike Petsche'
Subject: RE: ECN09-626

The longer stud will work for both thick/thin flange situations, at most the head will stick 0.06" further out on the -6 stud vs the -4 stud. There's no IIN or DSI instruction the customer to switch the studs or telling them how to do it, so I think we should just install the -6's. That would be the easiest / seamless solution for the customer in my opinion.

-Chris

From: Jason Murdoch [mailto:jmurdoch@dartaero.com]
Sent: August 7, 2009 8:34 AM
To: 'Dan Stow'; 'L Lacelle'; 'Mike Petsche'; 'Provencal, Chris'
Subject: RE: ECN09-626

Well like I said, lets make it optional to the customer, and include them in the kit. Done deal.

Jason Murdoch
Quality Coordinator
jmurdoch@dartaero.com

From: Dan Stow [mailto:dstow@dartaero.com]
Sent: August 7, 2009 8:31 AM
To: 'Jason Murdoch'; 'L Lacelle'; 'Mike Petsche'; 'Provencal, Chris'
Subject: RE: ECN09-626

Well obviously you need to replace the retaining washer also.... Duh. I have had a few complaints and when Russ did a trial fit the same issue came up. It really depends on how thick Delastek feels like making the flange.

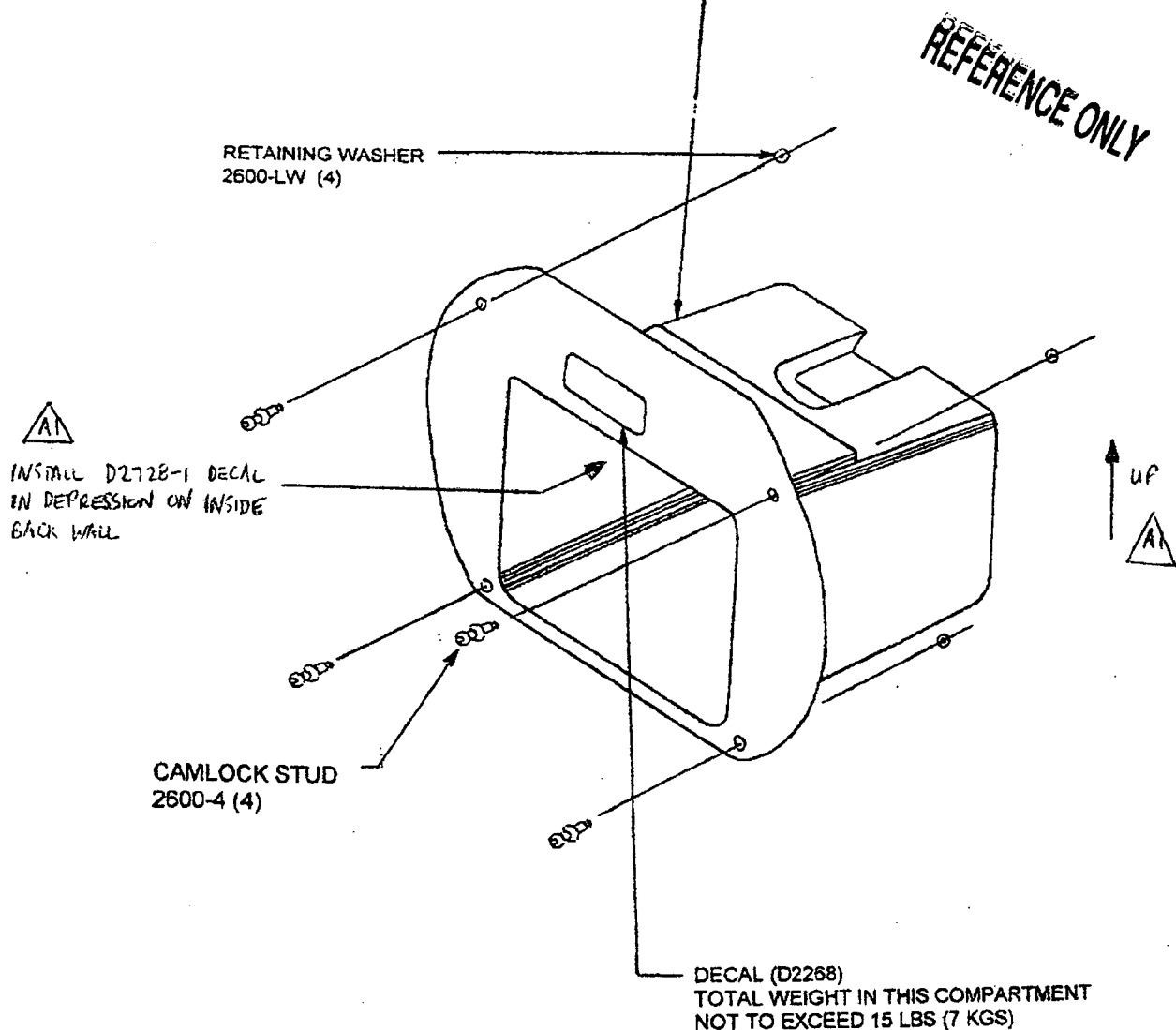
Dan Stow
Technical Support
Dart Aerospace Ltd.
dstow@dartaero.com
Tel: 613.632.5200
Cell: 613.676.0992

8/07/09



DESIGN BW	DRAWN BY JP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED CH	APPROVED [Signature]	DRAWING NO. D350-604-041	REV. A SHEET 1 OF 1
DATE 02.04.01		TITLE REAR LOCKER EXTENDER ASSEMBLY	SCALE MTS
A	02.04.01	NEW ISSUE	
A1	RF 02.04.23	ADD D2728-1 DECAL + ORIENTATION NOTE REAR LOCKER EXTENDER (D2273)	

RELEASED
02.04.03



D350-604-041 REAR LOCKER EXTENDER

NOTE: DECALS TO BE ORIENTED TO MATCH 'UP' ORIENTATION OF RLE

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ENGINEERING CHANGE NOTICE **DART AEROSPACE LTD**

Date: 09.07.14	Job No.: ENG0106JUL	ADR Yes/No: <input checked="" type="checkbox"/> Y	ADR Date: 09.07.14	ECN #: 09- 626
Product No.: D350-604		Created By: <i>JP</i>	Approved By: <i>MD</i>	
Product Name: REAR LOCKER		Checked By: <i>JP</i>	General Manager Approval:	

Distribution	Reqd	Resp	Initial / Date
Production Manager	Y	LL	
Production Engineering Coord	Y	EC/DD	
Production Document Control	Y	<i>EL</i>	
Customer Technical Support	Y	DStw	

Distribution	Reqd	Resp	Initial / Date
DQA / QA Coord	N		
QC Coordinator	Y	JM	
Marketing	Y	SW	
Customer Order Processing	N		

Reason for Change:
NCR 09-046

Documents Affected:
RELEASE DSI 9470 REV. A

PARTS MUST COMPLY ☒ PREVIOUS PARTS SATISFACTORY ☐

#	Quality Assurance Actions	Reqd	Resp	Notes	Complete
1	Notify Previous Customers	N			
2	Notify Eurocopter France	N			
3					

#	Engineering Actions	Reqd	Resp	Notes	Complete
4	Required Documents/Drawings Under Review	N			
5	Update Product Compatability Matrix	N			
6	Create Eurocopter Form (FEE)	N			
7	Notify TC / FAA of Change	N			

#	Document Control Actions	Reqd	Resp	Notes	Complete
8	Move Electronic Files	Y	KJ		09.07.15 <i>JP</i>
9	Update Blue/Pink/DSI Folder and Electronic Files	Y	KJ		09.07.15 <i>JP</i>
10	Update Controlled PDF Files	Y	KJ		09.07.15 <i>JP</i>
11	Update Master Document List (MDL)	N			
12	Update Document Record (DR)	Y	KJ	Rev. D	09.07.15 <i>JP</i>
13	Update Product Development Summary	N			
14	Update QSI 021 and/or STC Approval List	N			
15	Update Parts / STG Database	Y	KJ	CHG 002 For D350-604-041	09.07.15 <i>JP</i>
16	Update / Verify ARC Database	N			
17	Create / Update Change Record Form	Y	KJ	CHG 002	09.07.15 <i>JP</i>
18	Create / Update PPP's	Y	KJ		09.07.15 <i>JP</i>
19	Update Document Control Database / Laminated Dwgs	N			
20	Update Grey Project Binder	Y	CP		09.07.14 <i>JP</i>
21	Update D-Part/M-Drawing/DSI/DEO Master Binders	Y	KJ		09.07.15 <i>JP</i>
22					
23					

Description / Action:

- DSI 9470 REPLACES 2600-4 CAMLOC STUDS WITH LONGER 2600-6 CAMLOC STUDS. F.R. D350-604-041 - 10 stk.
- D350-604-041 KIT NOW AT CHG 002
- UPDATE ALL D350-604-041 KITS IN STOCK TO ADD QTY(4) 2600-6 CAMLOC STUDS AND LABELS FOR CHG 002, & ADD DSI 9470

REFERENCE ONLY

MD 09/13

ECN Verified & Complete: _____ Date: _____